



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D212-664-201TRN
Job Sheet 173487



Part No: D212-664-201TRN

Job Qty: 1 ea

Part Name: Crosstube Turning Detail



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/2/18

Job Tracking No:

Due Date: 3/16/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV E IPP Rev:A 08-03-06 new issue DD verified by:ec IPP Rev B 08.04.02 Removed polish EC verified DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	3/15/18	3/15/18	0.00	0.00	Start Up Crosstubes-2		PMP
100	Mori Seiki	1 pcs	3/15/18	3/15/18	0.00	1.33	Mori Seiki TL-40		PMP
110	QC	1 pcs	3/15/18	3/15/18	0.00	0.00	QC1 QC2		PMP
120	Mori Seiki	1 pcs	3/15/18	3/15/18	0.00	1.33	Mori Seiki TL-40		PMP
130	QC	1 pcs	3/15/18	3/15/18	0.00	0.00	QC1 QC2		PMP
140	QC	1 pcs	3/15/18	3/15/18	0.00	0.00	QC8		PMP
145	Crosstubes	1 pcs	3/15/18	3/15/18	0.00	0.25	Crosstubes-2		SA 18-05-02
150	HandFXtube	1 pcs	3/16/18	3/16/18	0.00	0.25	Crosstubes-3		SA 18-05-02
160	QC	1 pcs	3/16/18	3/16/18	0.00	0.00	QC7-1		SA 18-05-02
170	Packaging	1 pcs	3/16/18	3/16/18	0.00	0.00	Packaging3-1		SA 18-05-02
180	QC21-SA	1 Ea	3/16/18	3/16/18	0.00	0.00	QC21		SA 18-05-02

Part Op 100 - 1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA114 2-Turn first side as per Folio FA114
 Descriptions: 120 - 1-Turn second side as per Folio FA114
 145 - GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.
 150 - 1- handfinish X-TUBE INSIDE AND OUT
 170 - Identify and stock in kanban rack Location: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6006-129	Crosstube Material	1 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6006-129	1	71	0

B 123969

Part Specifications

Specifications could not be found.

Plex 3/2/18 10:48 AM Dart.Gagnon.Michelle



Container No: S048770



Part: D212-664-201TRN

Job No: 173487

Serial No/Batch: S048770

Revision:

Inspector:

Dart Aerospace Ltd.
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Date: 03/07/18

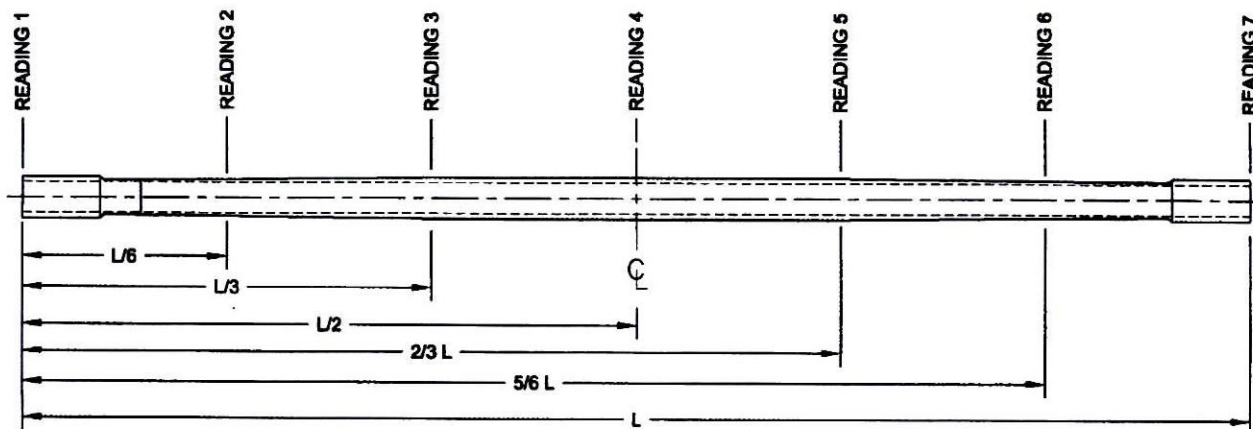
DART AEROSPACE LTD	Work Order:	173487
Description: Crosstube Assembly (205/212 High Aft)	Part Number:	D212-664-241
Inspection Dwg: D212-664-241 Rev: E		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	2.005 PMP ✓		VERN 08	
	R0.063	+/-0.010	.063 ✓		RG	
	2.990	+0.005/-0.000	2.993 ✓		VERN 08	
	5.237	+/-0.030	5.235 PMP ✓		"	
	2.600	+0.005/-0.000	2.6045 ✓		BLM 2"-3" 04	
	2.686	+0.005/-0.000	2.691 ✓		"	
	2.770	+0.005/-0.000	2.775 ✓		"	
	2.854	+0.005/-0.000	2.859 ✓		"	
	2.938	+0.005/-0.000	2.943 ✓		"	
	3.021	+0.005/-0.000	3.024 ✓		BLM 3"-4" 05	
	3.133	+0.005/-0.000	3.136 ✓		"	
	3.179	+0.005/-0.000	3.182 ✓		"	
	.500	±.010	.500 ✓		RG	
	.063	±.010	.063 ✓		RG	
	0.200	+/-0.010	2.00 PMP ✓		VERN 08	
SIDE B	R0.063	+/-0.010	.063 ✓		RG	
	2.990	+0.005/-0.000	2.993 ✓		VERN 08	
	5.237	+/-0.030	5.238 ✓		"	
	2.600	+0.005/-0.000	2.605 ✓		BLM 2"-3" 04	
	2.686	+0.005/-0.000	2.691 ✓		"	
	2.770	+0.005/-0.000	2.775 ✓		"	
	2.854	+0.005/-0.000	2.859 ✓		"	
	2.938	+0.005/-0.000	2.943 ✓		"	
	3.021	+0.005/-0.000	3.0255 ✓		BLM 3"-4" 05	
	3.133	+0.005/-0.000	3.1375 ✓		"	
	3.179	+0.005/-0.000	3.1835 ✓		"	
	124.362	+/-0.020	124.360 ✓		TAPE	
	.500	±.010	.500 ✓		RG	
	.063	±.010	.063 ✓		RG	

DART AEROSPACE LTD	Work Order: 173487
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WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L = 0"	412	395	388	408	.024	0.062"
READING 2 L = 20.73	329	322	321	329	.007	
READING 3 L = 41.45	485	490	495	493	.010	
READING 4 L = 62.18	515	522	532	528	.017	
READING 5 L = 82.91	482	492	498	494	.016	
READING 6 L = 103.64	317	327	330	324	.013	
READING 7 L = 124.362	412	410	391	397	.021	

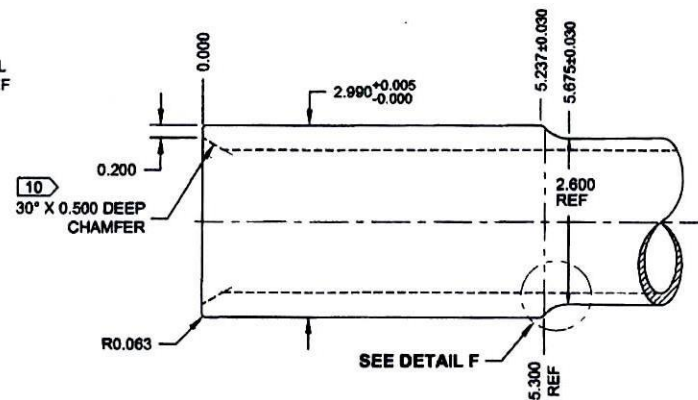
Calibration Result

Actual Block Thickness: 100-500

Sitiescan 250 Measured Thickness: 200-500

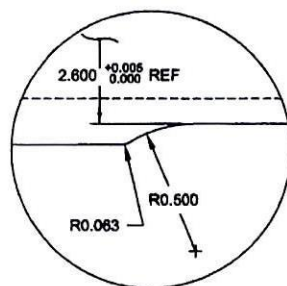
Measured by: PMP	Audited by: JW	Preliminary Approval:
Date: 2018-03-07	Date: 18-03-28	Date:

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-201)	KJ/JLM	
B	06.03.09	Tolerance for 5.237 was +/-0.001	KJ/JLM	
C	07.05.08	Dwg Rev. updated	KJ/JLM	
D	10.08.03	Dimension 124.362 was 124.36	KJ	
E	12.06.04	Wall thickness form added	KJ	
F	15.03.03	Dwg Rev updated	KJ	

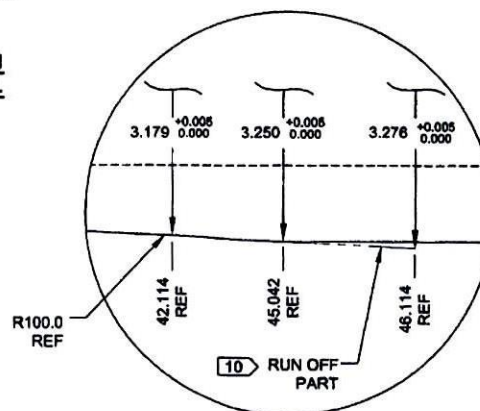


MAR 02 2018

RELEASE
2014-05-26



D212-664-241TRN
TURNING DETAIL



DETAIL E:
TAPER RUN-OFF
NOT TO SCALE

DESIGN	90	DART AEROSPACE LTD	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	90	DRAWING NO.	REV. E
MFG. APPR.	90	D212-864-241	SHEET 5 OF 5
APPROVED	90	TITLE	SCALE
DE APPR.	90	CROSSTUBE ASS'Y (205/212 HI AFT)	NTS
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